

Work Order ID 109627

May-16-14 8:39:20 AM

109627

Page 1

Item ID: D3954-5

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Chain Lug

Start Date: 11/27/13 Start Qty: 4.00 *4*

Cust Item ID:

Required Date: 12/02/13 Req'd Qty: 4.00 *4*

Customer:

Reference:

Approvals: Process Plan: W Date: Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3954	D								

100 0.00

~~*100*~~

~~Mill Conv~~

~~Conventional Milling Machine~~

~~Memo~~

~~mill to size~~

0.00

N/A MCO 1406-11
4 0 1406-4

110

0.00

110

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg D3954

Dwg Rev: D

Prog Rev: D

2-Deburr if necessary

0.00

4 0 1406-4

30# 1" x 2"

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Page 2

Item ID: D3954-5

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N900040100

Setup Start ***NS1***

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Start Date: 11/27/13 Start Qty: 4.00 ***4***

Cust Item ID:

Required Date: 12/02/13 Req'd Qty: 4.00 ***4***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00				4	0		Jm 14-06-4
120									
QC	Memo	0.00							
Quality Control									
125		0.00				4	0		14-6-10
125									
Mill Conv	Memo	0.00							
Conventional Milling Machine	Open hole using 0.748" reamer and mill as per Dwg								
130	QC8- Inspect parts - second check	0.00				4	0		DAS 08 9-89
130									
QC	Memo	0.00							
Quality Control									

DAS
13
9-89

B.A 14/06/11

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Page 3

Item ID: D3954-5

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Chain Lug

Start Date: 11/27/13

Start Qty: 4.00

4

Cust Item ID:

Required Date: 12/02/13

Req'd Qty: 4.00

4

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Stop

NR2

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

Identify as per dwg & Stock Location: W/1002

0.00

140

Packaging

Memo

0.00

Packaging

4 02 14-6-10

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

MLJ 14-6-11

MLJ 14-6-11

Picklist Print

Page 1

May-16-14 8:39:20 AM

Work Order ID: 109627

109627

Parent Item: D3954-5

D3954-5

Parent Item Name: Chain Lug

Start Date: 11/27/13

Required Date: 12/02/13

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 11.08.16 AS PER REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M303B1.000X2.000

Purchased

No

100

f

44.7500

0.5

~~2.105263~~

M303B1 000X2 000

**

2.5

Jm14-06-4

303 BAR 1" X 2"

Location

Loc Qty

Loc Code

MAT049

44.75

m125822

8.75

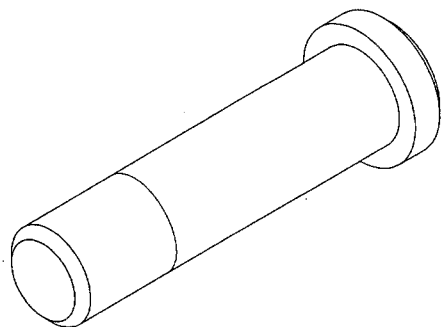
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12

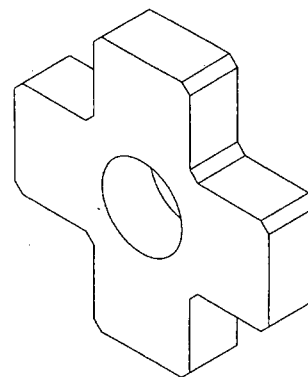
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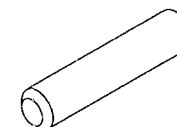
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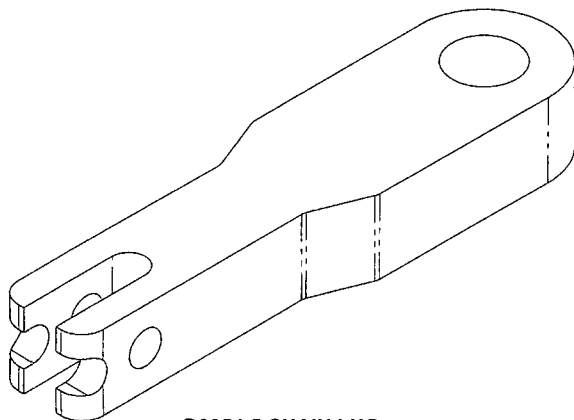
D3954-1 GWT PIN



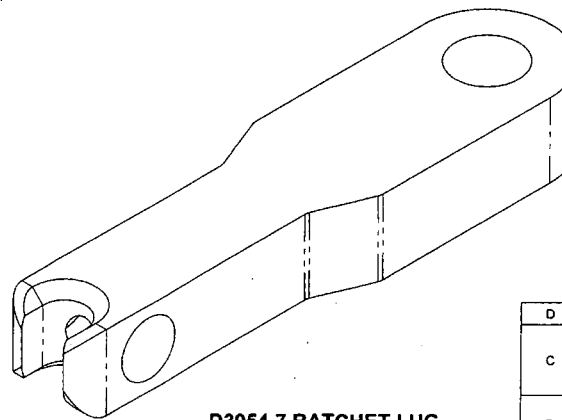
D3954-3 GWT KNOB



D3954-9 GWT CHAIN PIN



D3954-5 CHAIN LUG

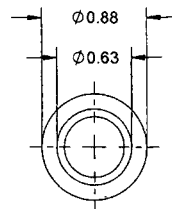


D3954-7 RATCHET LUG

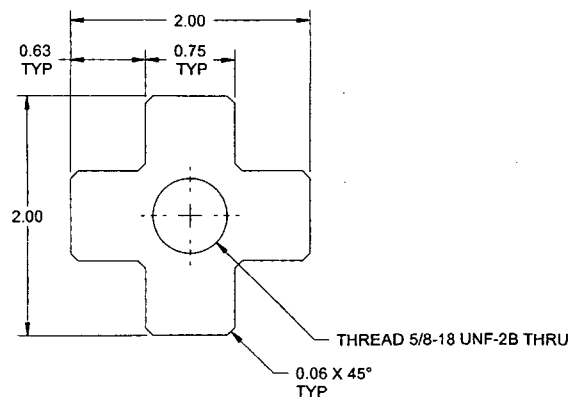
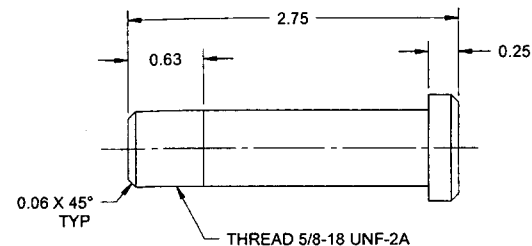
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2012-10-01

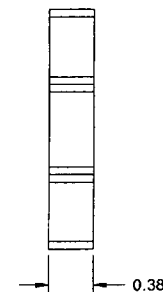
D	ZN A6-2, A6-3. REVISED NOTE 2 TO ADD POWDER COAT.	DC	12.08.10
C	MATERIAL UPDATE FOR D3954-1/-3: NOW STAINLESS STEEL ONLY (A6-2); FINISH CHANGED TO "NONE" FOR D3954-1/-3 (A6-2); TOLERANCE ON Ø0.750 WAS Ø0.75 MAX (D3-3 & D7-3); D3954-9 NOW A PURCHASED PART (A2/A6-3). REASON: PART11-113.	MB	11.07.27
B	MATERIAL UPDATE FOR ALL COMPONENTS WAS STAINLESS STEEL IS CARBON STEEL FOR ALL COMPONENTS. FINISH FOR ALL COMPONENTS WAS RED POWDER COAT IS YELLOW SPRAY PAINT.	AJS	09.10.15
A	NEW ISSUE	AJS	09.05.26
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS/DSTOW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	BC		
CHECKED	BC	DRAWING NO.	REV. D
MFG. APPR.	BC	D3954	SHEET 1 OF 3
APPROVED	BC	TITLE	SCALE
DE APPR.	N/A	MISC MACHINED PARTS GWT KIT	NTS
DATE	12.08.10	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. NO IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D3954-1 GWT PIN



D3954-3 GWT KNOB

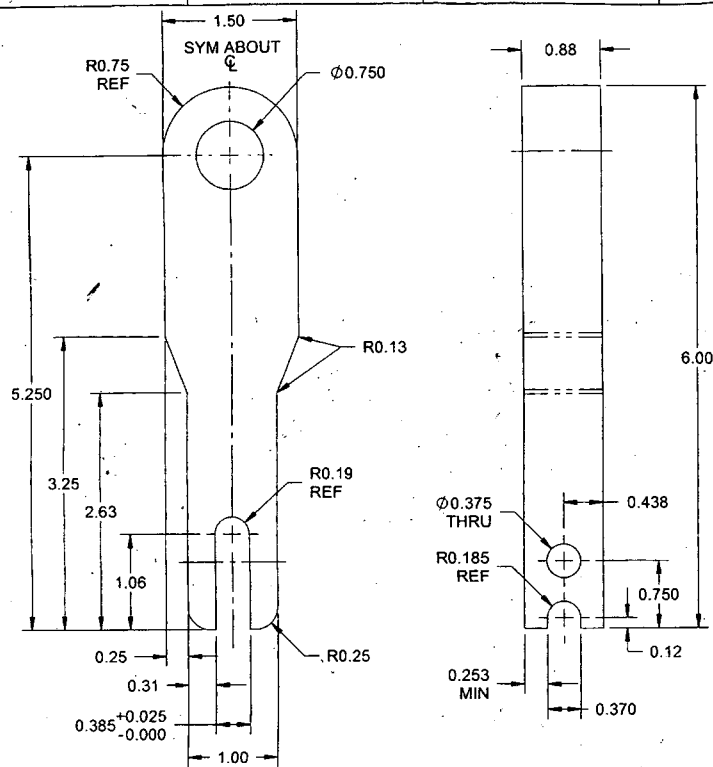


NOTES:

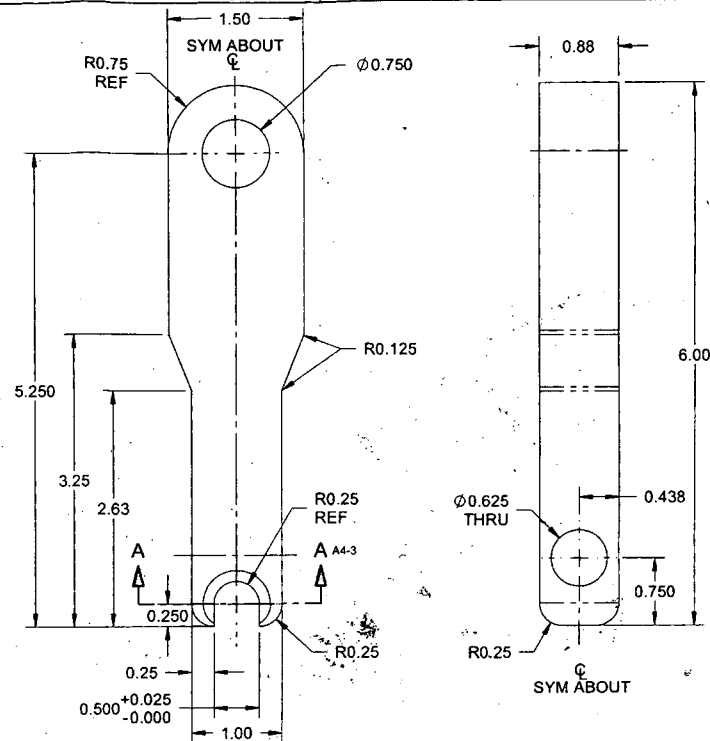
- 1) MATERIAL -1: AISI 303/304/316 STAINLESS STEEL ROUND BAR
PER ASTM A582 (303) OR ASTM A276 (304/316)
REF DART SPEC M303R OR M304R
- 3: AISI 303/304/316 STAINLESS STEEL SHEET
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316)
OR ASTM A240 OR ASME SA240
REF DART SPEC M303S OR M304S
- OR:
AISI 303/304/316 STAINLESS STEEL BAR OR AISI 304/316 PLATE
PER ASTM A582 (303) OR A276 (304/316) OR ASTM A240 (304/316)
REF DART SPEC M303B OR M304B
- 2) FINISH: SPRAY PAINT YELLOW WITH BERTRAND CG1031B PER DART QSI 005 4.2
OR POWDER COAT HYBRID SAFETY YELLOW (4.3.5.12) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT -1: 0.26 lbs
-3: 0.23 lbs

RELEASED
2012-10-01

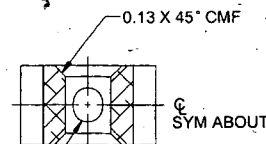
DESIGN	AJS/DSTOW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3954	REV. D
MFG. APPR.		SHEET 2 OF 3	
APPROVED		TITLE	SCALE
DE APPR.	N/A	MISC MACHINED PARTS GWT KIT	
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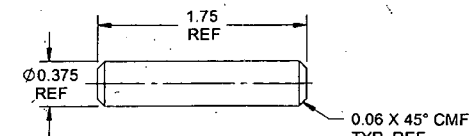
D3954-5 CHAIN LUG



D3954-7 RATCHET LUG



SECTION A-A C3-3



D3954-9 GWT CHAIN PIN

NOTES:
1) MATERIAL:

- 5/-7: AISI 1010-1025 MILD STEEL BAR
PER DART SPEC M1010-B
- 9: PURCHASE PART FROM MCMASTER-CARR:
P/N 98381A630 (MILD STEEL)

ALTERNATE MATERIAL:

- 5/-7: AISI 303/304/316 STAINLESS STEEL BAR OR AISI 304/316 PLATE
PER ASTM A582 (303) OR A276 (304/316) OR ASTM A240 (304/316)
REF DART SPEC M303B OR M304B
- 9: PURCHASE PART FROM MCMASTER-CARR:
P/N 90145A630 (STAINLESS STEEL)

- 2) FINISH -7 ONLY: SPRAY PAINT YELLOW WITH BERTRAND CG1031B PER DART QSI 005 4.2
OR POWDER COAT HYBRID SAFETY YELLOW (4.3.5.12) PER DART QSI 005 4.3 Δ
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT -5/-7: 1.56 lbs EACH
-9: 0.05 lbs REF

RELEASED
2012-10-01

DESIGN	AJS/DSTOW	DART AEROSPACE LTD	
DRAWN	DC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BE	DRAWING NO:	REV. D
MFG. APPR.	W	D3954	SHEET 3 OF 3
APPROVED	W	TITLE	SCALE
DE APPR.	N/A	MISC MACHINED PARTS GWT KIT	NTS
DATE	12.08.10	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

